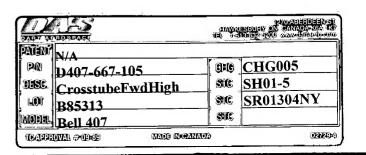
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Revision ID:	D407-667-105 Crosstube Fwd			Accept	*N900	040	100)*	Setup S	Start Stop	*N.5	S1*
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Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

89020 Friday, August 17, 2012 2:34:24 PM D407-667-105 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Crosstube Fwd **Start Date:** 8/17/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 8/24/2012 **Req'd Qty:** 1.00 **Customer:** Reference: NCR 12-1695 Run Start Approvals: Date: Tooling: Date: Stop SPC (Y/N): Date:____ Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 310 Identify as per dwg & Stock Location: 55 0.00 *310* Packaging Memo 0.00 Packaging ID AND STOCK UNDER NEW BATCH NUMBER AT CHG NUMBER 005 QC21- Final Inspection - Work Order Release 0.00

320

QC

Memo

0.00

Quality Control

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DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. D AND EARLIER AND

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. D AND EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 3 AND EARLIER REF: CANADIAN STC: SH01-5

REF: CANADIAN STC: SH01-5 REF: FAA STC: SR01304NY REF: EASA STC: EASA.IM.R.S.01179

PURPOSE:

The purpose of this service instruction is to permanently add the D206-667-017 Kit to the DXXX-667-101/-103/-105/-107 Crosstube kits.

INSTRUCTIONS:

DXXX-667-101/-103/-105/-107 Crosstubes at CHG 005/006/005/003 (respectively) and later are supplied with the D206-667-017 Grounding Strap Kit installed per section 3.2 of IIN-D206-667 Rev. D.

WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of this kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: 12.08.02 CERT. NO.: SH01-5 ISSUE NO.: 3

Α	NEW IS	SUE (REF CIR	(12-3)	AJS	11.08.02
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MFG. A	PPR.	N/A	DSI 9628	5	HEET 1 OF 1
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DE APF	PR.	#	GROUNDING STRAP INST	ALLAT	ION NTS
DATE	12.0	8.02	COPYRIGHT © 2012 BY DART AE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED OF NOT TO BE USED FOR ANY PURPOSE OR COPPED OR COMMERMICAT	IN THE EXPRESS O	ONDITION THAT IT IS

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	Inspection		Tube	<u> </u>	Cut Too Short		isread			Power Loss/	Surge	Other
	Ripples in	Bend		<u> </u>	Drill Holes	${f H}$	fset					
	Torque W	aves in F	xtrusion	1 I	Drawing	I lou	it of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 AND EARLIER

REF: CANADIAN STC: SH01-5 REF: FAA STC: SR01304NY REF: EASA STC: EASA.IM.R.S.01179

PURPOSE

The purpose of this service instruction is to add the optional D206-667-017 Kit and provide guidelines to install extra clamps on D206-667-101/-103 or D407-667-105 forward crosstubes to allow fastening of OEM grounding straps.

INSTRUCTIONS:

- 1) If installed, follow Section 32.1 of ICA-D206-667 for removal of the forward crosstube from the helicopter.
 2) Locate AN742D36 Clamp as shown in Figure 1 of this service instruction and mark location of clamp on the
- crosstube. 3) Remove crosstube finish (paint and primer) in area where AN742D36 Clamp will be installed and touch up

- affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.

 4) Install AN742D36 Clamp complete with MS9165-05 per Section A-A of Figure 1 of this service instruction.

 5) Touch up paint as required per Item 5.3.3 of ICA-D206-667.

 6) Seal edges where AN742D36 Clamp meets with crosstube using Sikaflex-241/291 or MIL-S-8802 Class B2 or Proseal 890 sealant.
- Prosear and Search.

 7) Install/re-install forward crosstube in accordance with Section 32.2 of ICA-D206-667.

 8) Fasten OEM grounding strap to MS9165-05 Angle Bracket on forward crosstube per Bell instructions.

 9) Undertake a resistance check between a ground point on the skidtube and aircraft ground in accordance with Class R-II requirement per BHT-ELEC-SPM. Maximum resistance is 10 milliohms (mΩ).

PARTS LIST:

QTY -017	PART NUMBER	DESCRIPTION					
X	D206-667-017	GROUNDING STRAP INSTALLATIO					
2	AN742D36	CLAMP					
2	MS9165-05	ANGLE BRACKET					
2	MS21042-3	NUT					
2	MS27039-1-08	SCREW					
4	NAS1149C0332R	WASHER					

WEIGHT AND BALANCE

CANADA

There is a negligible weight change associated with the installation of this kit.

DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 D. SHEPHERD (DE # 02) CERT. NO .: SH01-5

ISSUE NO .:

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MFG. A	PPR.	N/A	DSI 9544		SHEET 1 OF 2			
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DE APP	PR.	#	GROUNDING STRA	AP INSTALLA	TION NTS			
DATE	11.0	2.18	THIS DOCUMENT IS PROVATE AND COMPRENTIAL NOT TO BE USED FOR ANY PURPOSE OR COPIE		S CONDITION THAT IT IS			

									DQA:	Date:			
NCR: Yes	s / No				WORK ORDER NON-O	CONFORI	MANCE / UF		QA Closed:	Date:			
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.	Part No.				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
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General **Landing Gear** Grain Ovalized Pressure/Forced Bending Bend BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread Drill Holes Ripples in Bend Offset Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

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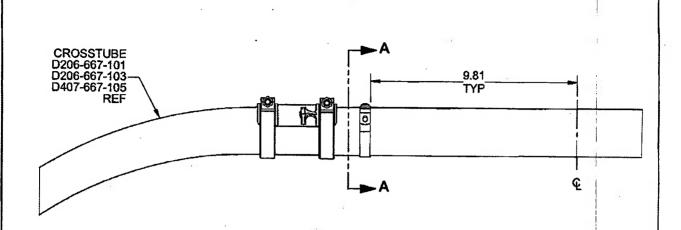
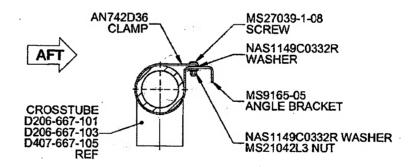


FIGURE 1 - GROUNDING STRAP INSTALLATION (VIEW LOOKING FWD)



SECTION A-A

(SUPPORT, CLAMP, CUSHION NOT SHOWN FOR CLARITY)
TYP, 2 PL PER CROSSTUBE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: __ CERT. NO.: __ ISSUE NO.: __

11.02.25 SH01-5 DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE
11.02.18

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA DRAWING NO.

DSI 9544

REV. A SHEET 2 OF 2

TITLE

GROUNDING STRAP INSTALLATION NTS

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	Ripples in Bend Drill Holes					Offset					
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